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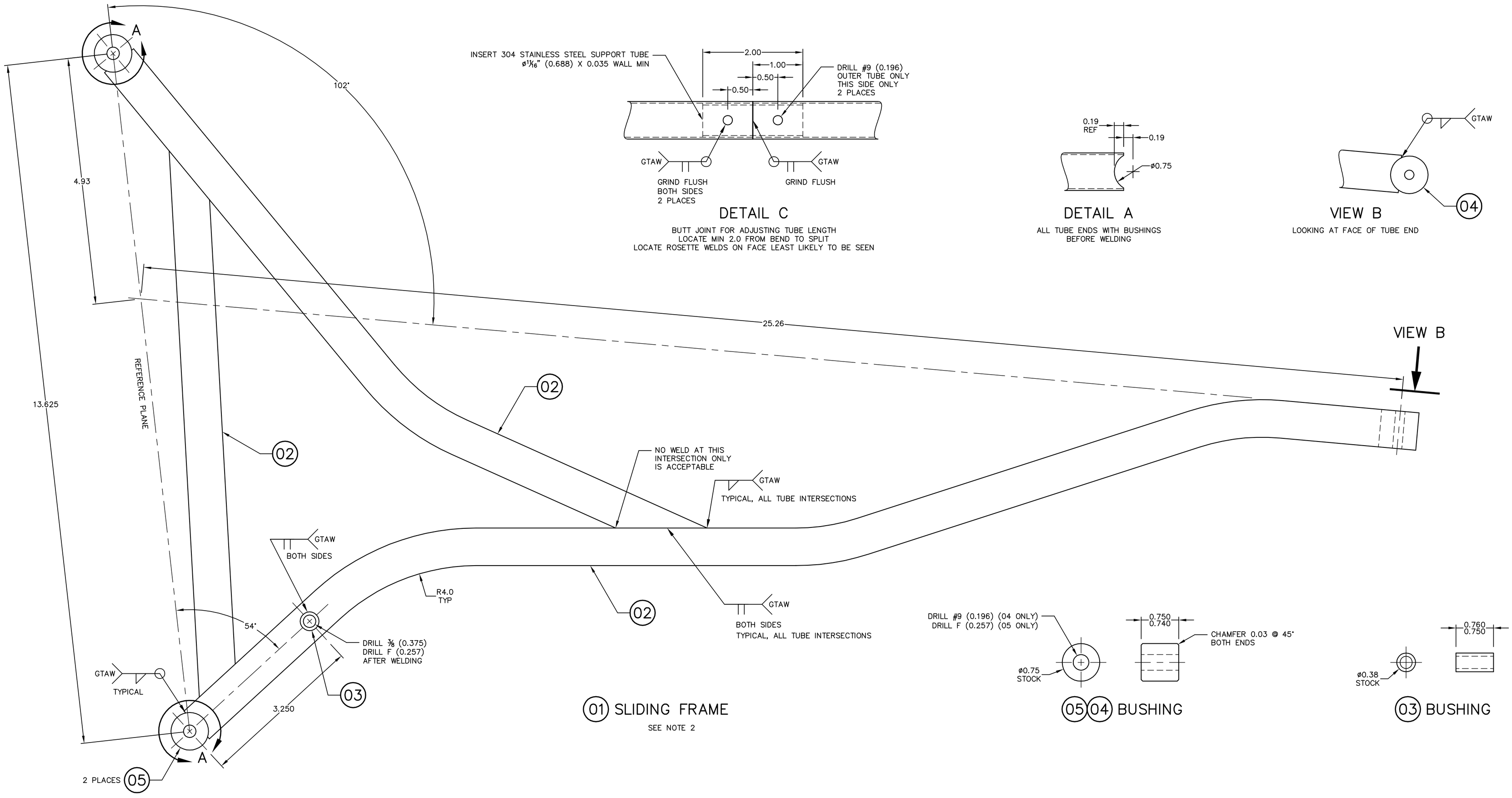
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



DETAIL C

BUTT JOINT FOR ADJUSTING TUBE LENGTH
LOCATE MIN 2.0 FROM BEND TO SPLIT
LOCATE ROSETTE WELDS ON FACE LEAST LIKELY TO BE SEEN

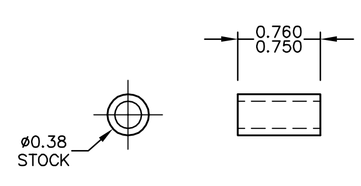
DETAIL A

ALL TUBE ENDS WITH BUSHINGS
BEFORE WELDING

VIEW B

LOOKING AT FACE OF TUBE END

05 04 BUSHING



03 BUSHING

01 SLIDING FRAME

SEE NOTE 2

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. USE FULL SCALE DRAWING AS TEMPLATE. CRITICAL DIMENSIONS SHOWN.
   INDIVIDUAL TUBE LOCATIONS AND ANGLES MAY VARY UP TO 1/16" (0.06) SO LONG AS CRITICAL DIMENSIONS ARE MAINTAINED.
   ENSURE BATCHED PARTS ARE IDENTICAL TO EACH OTHER.
   BUTT JOINTS MAY BE USED TO ACHIEVE REQUIRED LENGTHS, SEE DETAIL C.
3. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C.
   WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
4. FINISH – STAINLESS STEEL PARTS:
   FRAME MAY BE POLISHED USING SCOTCH BRITE WITH NO FURTHER COATING.
   ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT.
   ALTERNATE: THOROUGHLY DEGREASE, EPOXY PRIME AND POLYURETHANE PAINT.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
	LIST OF MATERIALS					
2	100220–05	05	BUSHING (0.75 X 0.257 ID)	304 STAINLESS STEEL	ASTM A479	ø0.75 ROD
1	100220–04	04	BUSHING (0.75 X 0.196 ID)	304 STAINLESS STEEL	ASTM A479	ø0.75 ROD
1	100220–03	03	BUSHING (0.375 X 0.245 ID)	304 STAINLESS STEEL	ASTM A269	ø0.375 X 0.065 TUBE
A/R	––	02	TUBE	304 STAINLESS STEEL	ASTM A554	0.75 X 0.035 SQR TUBE
	100220–01	01	SLIDING FRAME			

APPROVALS		DATE
DRAWN:	JEFF CLARKE	13 JUNE 2016
CHECKED:	JASON REKVE	13 JUNE 2016

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES ±1/2°

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AIRBUS HELICOPTERS AS350/AS355/EC130
BICYCLE RACK INSTALLATION
SLIDING FRAME FABRICATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	100220	0